

Work Order ID 82833

82833

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April-10-12 2:24:17 PM

Item ID: D205-626-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Handle RH
 Start Date: 10/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference: **S**

Approvals: Process Plan: MLJ Date: 12/04/10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D205-626	Rev B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 205-626-012		CHG 002	<i>Sirlosky</i>					<i>for MLJ 12-5-14</i> (5)

110	Pick Kit	0.00							
110									
Packaging	Packaging	0.00							
Packaging	Memo								
	Pick Packing Kit								<i>12/5/14</i>

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control			<i>Sirlosky</i>						(45) <i>RH</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82833***82833***

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Item ID: D205-626-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Handle RH

Stop ***NS2***

Start Date: 10/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				(5)		12/15/15	
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-626-012								
	Location: <u>22</u>								
	PPP Rev: <u>b</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/15/15

ME
12-05-16

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82833

82833

Parent Item: D205-626-012

D205-626-012

Parent Item Name: Heli-Access-Handle RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Reformat 00-03-03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN526C632R7

Purchased

No

110

Each

194.0000

6 24

**

AN526C632R7

Screw

Location

Loc Qty

Loc Code

ST347

194

112385

136

117317

58

D2480-012

Manufactured

No

110

Each

0.0000

1 4

**

D2480-012

Heli-Access Handle Weldment RH

MS21042L06

Purchased

No

110

Each

182.0000

6 24

**

MS21042L06

Nut

Location

Loc Qty

Loc Code

ST300

182

118354

2

119109

1

119758

1

120360

178

NAS1149DN632J

Purchased

No

110

Each

368.0000

6 24

**

NAS1149DN632J

Washer

Location

Loc Qty

Loc Code

ST298

368

118428

368

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-626 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-626-011	1.3 lb	-46.5 in	-60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH	0.59 kg	-1.18 m	-0.70 m-kg	2.21 m	1.31 m-kg
D205-626-012	1.3 lb	46.5 in	60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH	0.59 kg	1.18 m	0.70 m-kg	2.21 m	1.31 m-kg
D205-626-013	1.3 lb	-50.5 in	-65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH (Spacedoor™)	0.59 kg	-1.28 m	-0.76 m-kg	2.21 m	1.31 m-kg
D205-626-014	1.3 lb	50.5 in	65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH (Spacedoor™)	0.59 kg	1.28 m	0.76 m-kg	2.21 m	1.31 m-kg

5. PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D205-626-011	HELI-ACCESS-HANDLE™, LH (STANDARD)
	X			D205-626-012	HELI-ACCESS-HANDLE™, RH (STANDARD)
		X		D205-626-013	HELI-ACCESS-HANDLE™, LH (SPACEDOOR™)
			X	D205-626-014	HELI-ACCESS-HANDLE™, RH (SPACEDOOR™)
1		1		D2480-011	HANDLE ASSEMBLY, LH
	1		1	D2480-012	HANDLE ASSEMBLY, RH
		2	2	D2481	DOUBLER
		2	2	80-005-1-8	INSERT
6	6			AN526C632R7	SCREW
6	6			MS21042L06	NUT
		4	4	MS21042L08	NUT
		2	2	MS27039-0805	SCREW
		4	4	MS27039-0809	SCREW
6	6			NAS1149DN632J	WASHER (OR AN960JD6)
		10	10	NAS1149FN816P	WASHER (OR AN960-8L)

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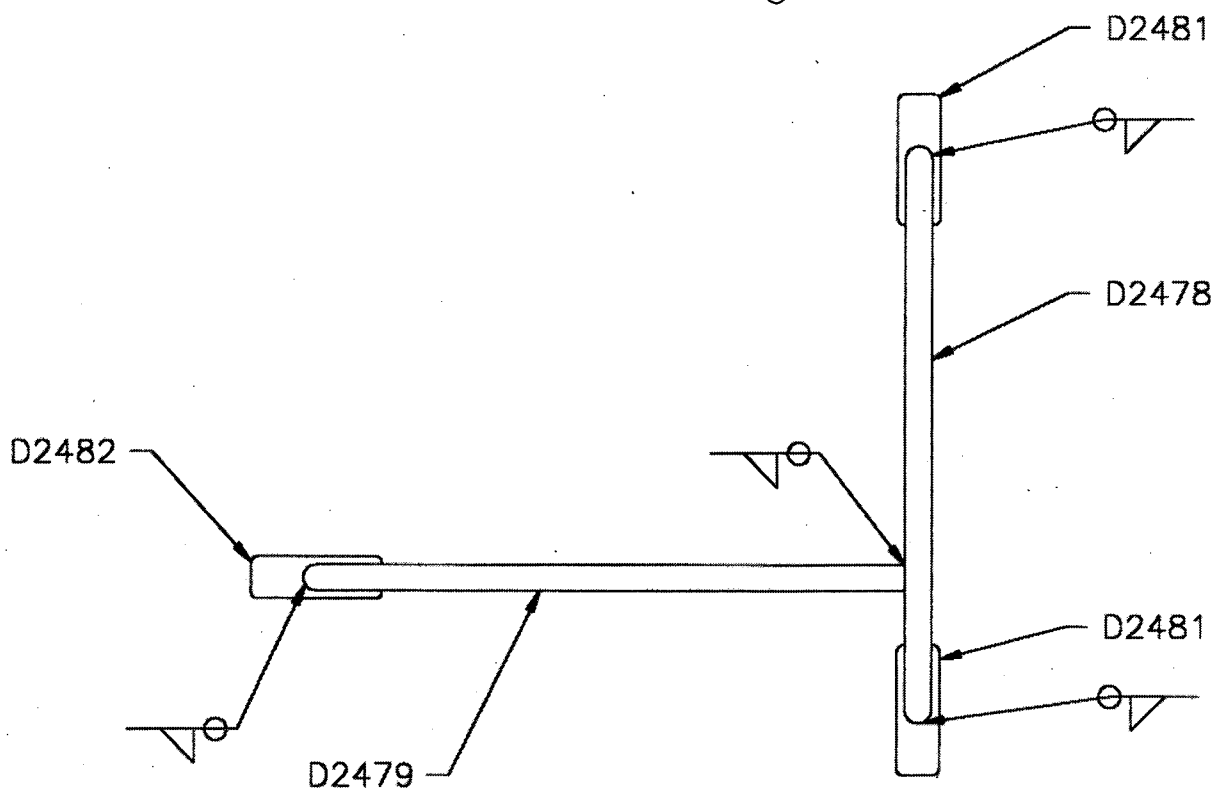
Revision: C
Date: 11.02.24



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS

REFERENCE ONLY
8



D2480-011 LH SHOWN
~~D2480-012 RH OPPOSITE~~

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER DSI 004
A1 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005